



5/08 (7)

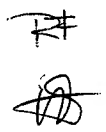
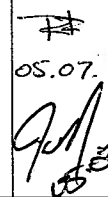
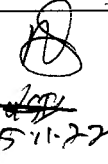
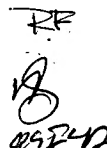
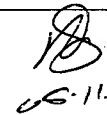
DART AEROSPACE LTD	Work Order:	22289
Description: Main Body	Part Number:	D3372-1
Dwg: D3372 Rev. A <i>page 4</i>	Qty:	25 26
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>[Signature]</i>	05.01.25	25 25
2	MV	Cut blank: 1.500" x 3.000" x 4.450" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B3.000x01.500) Identify for D3372-1 Batch: <i>Mt6530</i>	<i>J.L</i>	05.07.12	25
3	MV	Machine D3372-1 as per Folio FA496 and Dwg D3372 Identify as D3372-1	<i>[Signature]</i>	05.07.14	25
4	QC2	Inspect parts as they come off the CNC machine	<i>[Signature]</i>	05.07.14	25
5	QC8	Second check	<i>[Signature]</i>	05.07.14	26
6	MV	Deburr	<i>[Signature]</i>	05.07.14	25
7	QC5	Inspect work to Step 6	<i>[Signature]</i>	05.07.14	26
8	FP	Chemical Conversion Coat as per QSI 005 4.1	<i>[Signature]</i>	05.07.14	26
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask all holes	<i>[Signature]</i>	05.11.15	26
10	QC3	Inspect Powder Coat	<i>CY</i>	05.11.15	26
11	ST	Identify and Stock <i>Loc 59</i>	<i>[Signature]</i>	05.11.16	26 <i>C2</i>
12	AC	Cost / part <i>16.32</i>	<i>Syc</i>	05.11.21	26
13	DC	Close W/O <i>16.32</i> Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	05.01.18	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
05.01.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.07.13		- update dimension sheets	J-L	05.07.13		 05.11.22	 05.11.22

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.07.13	3	- 1 part chamfer dimension is .730 instead of .630 - error in program - is part acceptable?		IT IS ACCEPTABLE FOR (1) PART FOR THIS W/O. UPDATE CNC PROGRAM TO CORRECT THE DIMENSION AS PER DUG.	 05.07.13 05.11.22	 05.11.22	 05.11.22	 05.11.22

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/11/22

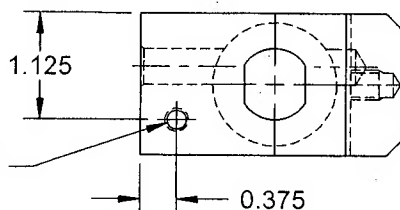
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED F	APPROVED [Signature]	DRAWING NO. D3372	REV. B
DATE 05.02.23		TITLE COLLECTIVE LOCK	SHEET 4 OF 8 SCALE 1:2

RELEASED
05/04/28



2 DRILL $\phi 0.201 \times 0.600$ DEEP
TAP $1/4-20 \text{ UNC} \times 0.400$ DEEP

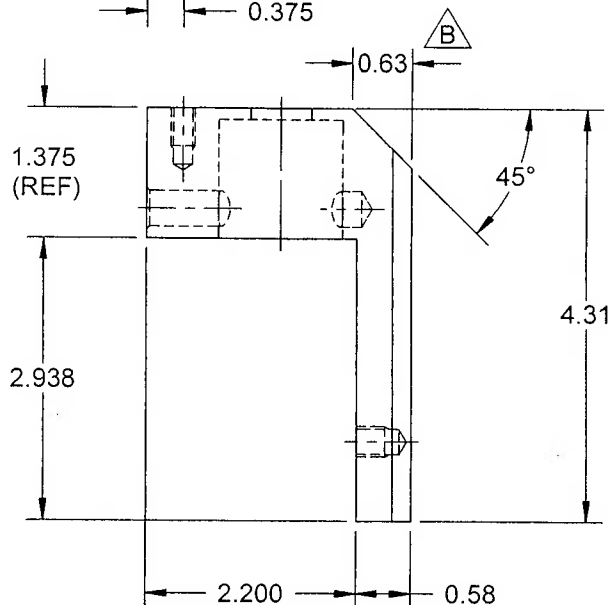
2 DRILL $\phi 0.377$,
2.363 DEEP.
CHAMFER $0.031 \times 45^\circ$

0.313

2.108

2 DRILL "I" DRILL
 $\times 0.525$ DEEP
THREAD $5/16-24 \text{ UNF}$
 $\times 0.300$ DEEP

0.750



SHOP COPY

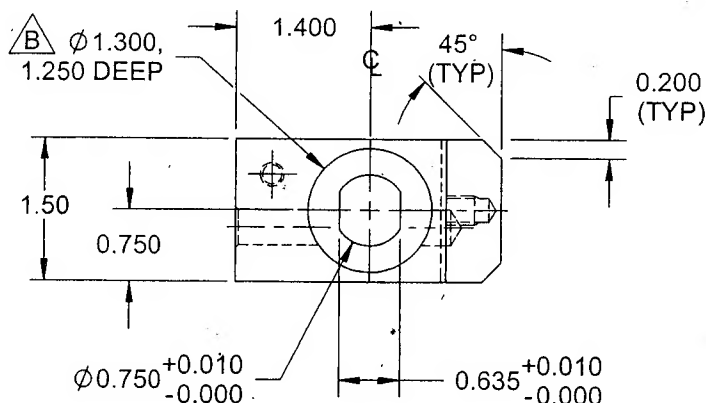
RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 22289



D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order:	22289
Description: Main Body		Part Number:	D3372-1
Inspection Dwg: D3372 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.377	+0.006/-0.000	0.379	✓		Vern	
0.313	+/-0.010	0.311	✓		Vern	
0.750	+/-0.010	0.748	✓		Vern	
1.375	+/-0.010	1.370	✓		Vern	
2.938	+/-0.010	2.937	✓		Vern	
0.575	+/-0.010					
2.200	+/-0.010	2.200	✓		Vern	
4.31	+/-0.030	4.316	✓		Vern	
1.50	+/-0.030	1.497	✓		Vern	
Ø1.300 Ø1.200	+0.005/-0.000	1.200	✓		Vern	
1.400	+/-0.010	1.399	✓		Vern	
0.635	+0.010/-0.000	0.636	✓		Vern	
0.750	+/-0.010	0.749	✓		Vern	
0.200	+/-0.010	0.205	✓		Vern	
Ø0.750	+0.010/-0.000	0.750	✓		Vern	
1.100	+/-0.010					

Measured by:	J.L	Audited by:	EC	Prototype Approval:	N/A
Date:	05.07.13	Date:	05.07.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED
05.05.13

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 25, 2005
03:20 pm

Work Order No : 0022289
Project Name : D3372-1
Project For : WK508
Work Order Type : Main
Main WO Number :
House Part Number : D3372-1
Description : Main Body
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 01-25-05
Est Finish Date : 02-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:12 am

Work Order No : 0022289
Project Name : D3372-1
Project For : WK508
Work Order Type : Main
Main WO Number :
House Part Number : D3372-1
Description : Main Body
Manufactured : Yes
Amount Req'd : 25
Amount Done : 0
Start Date : 01-25-05
Est Finish Date : 02-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	17.50	100.00		
Production Cost :	0.00	304.07	100.00	0.00	304.07
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	16.25	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	304.07	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	304.07			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-304.07)

MUS 01/13
u
11-13

Date: Monday, 14/11/2005 8:43:54 AM
 User: Alba Panzuto

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MAIN BODY	
Job Number :	22289			
Estimate Number :	10446			
P.O. Number :		Part Number :	D33721	
This Issue :	14/11/2005	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D3372 REV B	
First Issue :	/ /	Project Number :		
Previous Run :		Drawing Revision :	B	
	Type :	Material :		
	MACHINED PARTS	Due Date :	30/11/2005	Qty: 25 Um: Each
Written By :				
Checked & Approved By :				
Comment :	Est. A 05.01.18 New issue KJ/JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B3000X01500	6061-T6 Bar 3" x 1.5"
-----	--------------------	-----------------------

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: Cut blank: 1.500" x 3.000" x 4.450" long
 Machine D3372-1 as per Folio FA496 and Dwg D3372
 Identify as D3372-1
 Deburr

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------

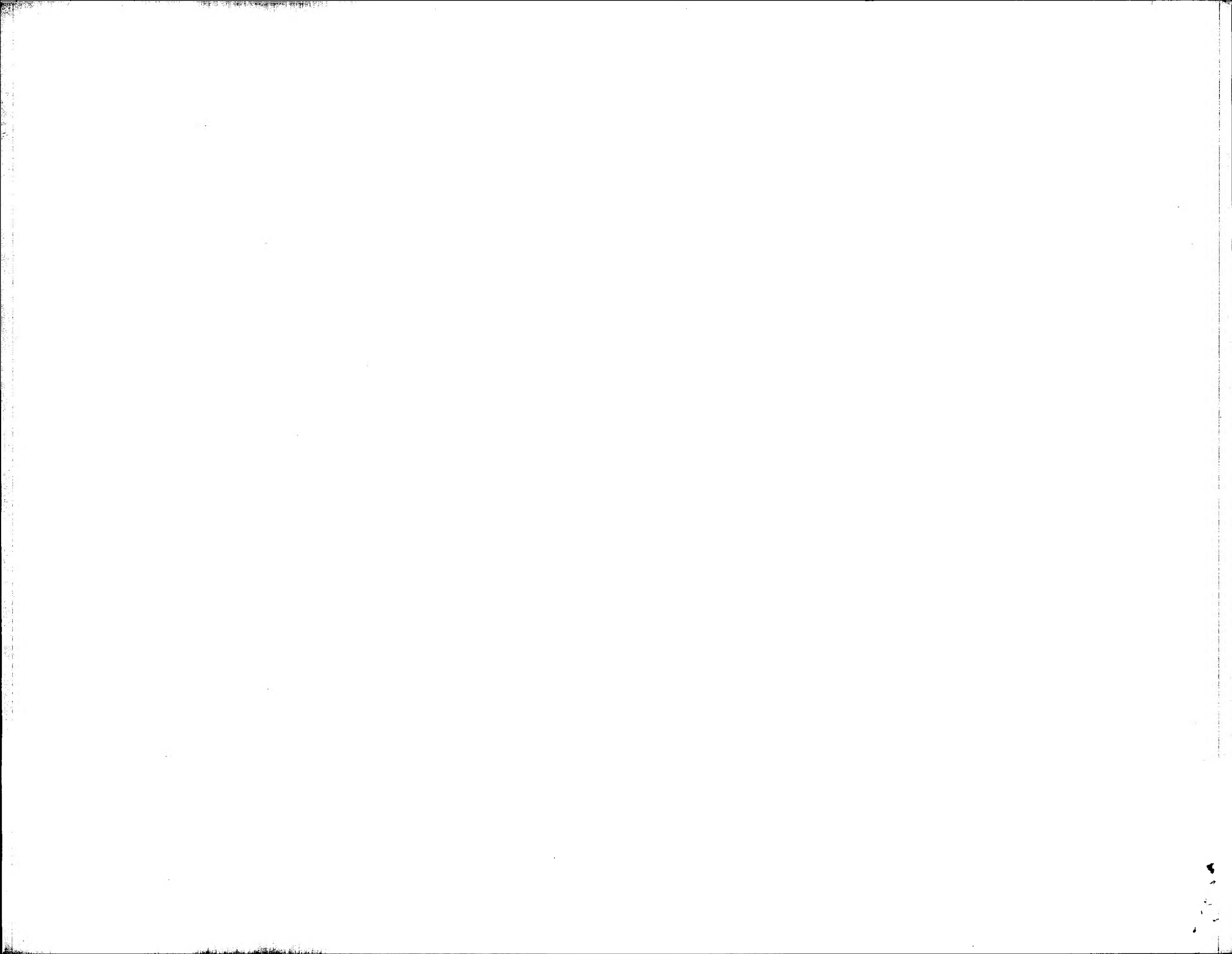


Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

6.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING
 Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3



Date: Monday, 14/11/2005 8:43:54 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAIN BODY

Job Number: 22289

Part Number: D33721

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

